

Date: Tuesday, 03/02/2009 11:00:14 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BASE
Job Number : 45453	
Estimate Number : 13037	
P.O. Number :	Part Number : D365113
This Issue : 03/02/2009 S.O. No. :	Drawing Number : D3651 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 44676	Material :
Written By :	Due Date : 10/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.02.03</u>	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC	
Est Rev:B ECN 1113P 08-01-22 DD	
Est Rev:C ecn1162 08-04-02 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.7140 sf(s)/Unit Total : 4.2840 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 109398 RB 9-2-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3651
 Dwg Rev: B
 Prog Rev: B

RB 9-2-4

(6)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RB 9-2-4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/02/04

(46)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and stock
 Location: E A

SR 02/02/04

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 11:00:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 45453

Part Number: D365113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45453
Description: Outside Doubler		Part Number: D3651-13
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

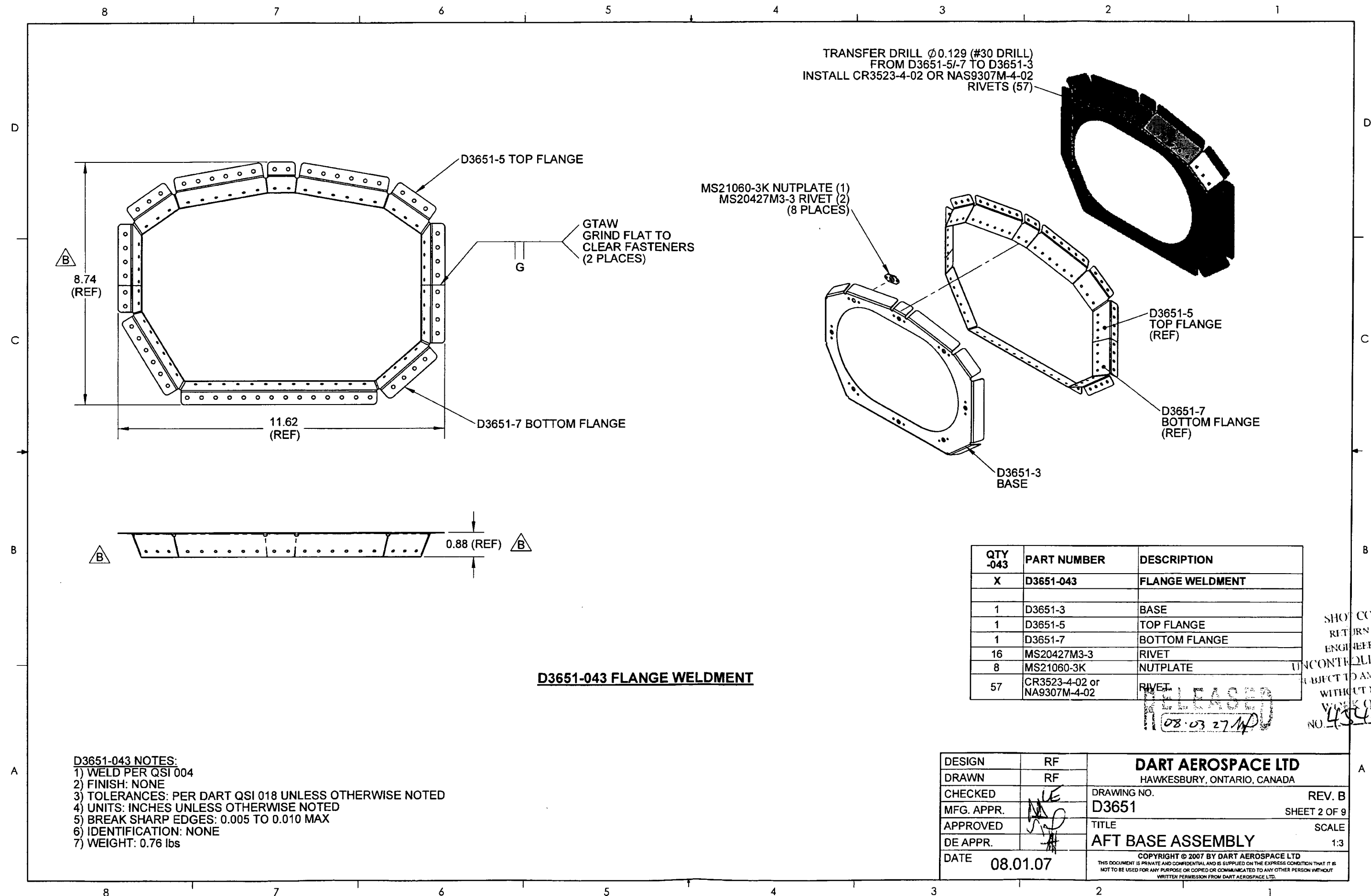
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	X			
0.260	+/-0.010	.262	X			
2.471	+/-0.010	2.473	X			
9.791	+/-0.010	9.797	X			
0.634	+/-0.010	.635	X			
2.564	+/-0.010	2.563	X			
0.52	+/-0.030	.523	X			
0.600	+/-0.010	.601	X			
0.500	+/-0.010	.499	X			
7.969	+/-0.010	7.970	X			
2.348	+/-0.010	2.347	X			
0.480	+/-0.010	.483	X			
5.571	+/-0.010	5.574	X			
0.696	+/-0.010	.695	X			
7.049	+/-0.010	7.047	X			
3.564	+/-0.010	3.558	X			
0.694	+/-0.010	.693	X			
1.779	+/-0.010	1.780	X			
8.74	+/-0.030	8.735	X			

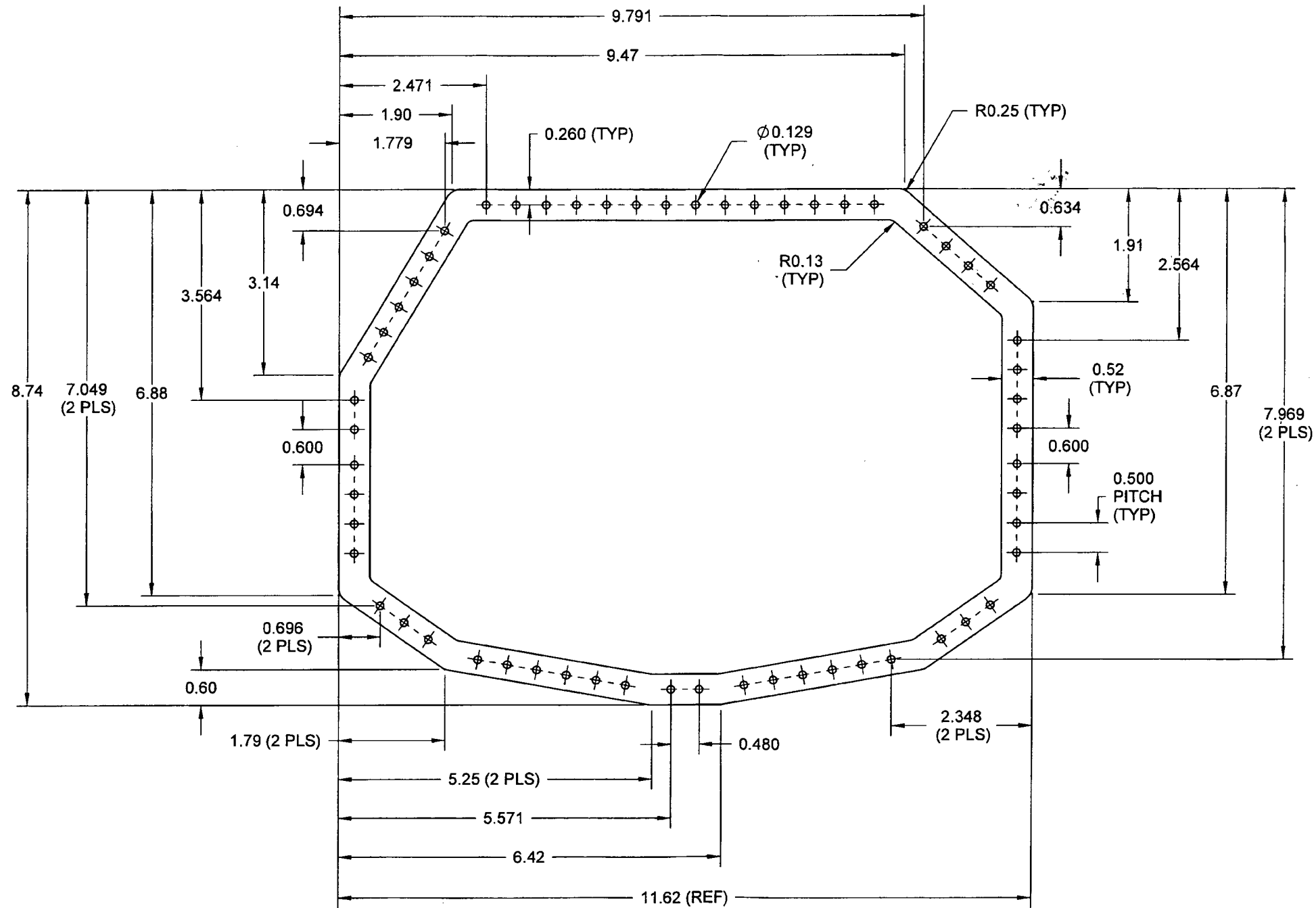
Measured by:	B
Date:	9-2-4

Audited by:	S
Date:	09/02/04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

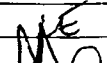




D3651-13 OUTSIDE DOUBLER B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DATE 08-03-27
NO. 45453